

Work Order ID 67772

Wednesday, March 30, 2011 10:36:32 AM



Page 1

Item ID: D3278-1

Accept



Setup Start



Revision ID:

Item Name: Support

Stop



Start Date: 3/30/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan:

Date: 11/03/30 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3278	Rev C

100



BAND SAW

Bandsaw

Jeaspa Bandsaw

0.00

110



HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

0.00

120



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 3/30/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center ID
130Operation
Description
QC8- Inspect parts - second checkSet Up/
Run Hours
0.00Tool ID
B.ATool #
11/04/07Plan
CodeAccept
Qty
41Reject
Qty
0Reject
NumberInsp.
StampQC
Quality Control

140



Chemical Conversion Coat per QSI005 4.1

0.00

41

BL 11-4-8

HandFinish
Hand Finishing

Memo

0.00

150



White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

41

BL 11-4-12

Powder Coating

M 116964

Memo

0.00

START TIME:
8:00

8:10

OVEN TEMPERATURE:
8140FINISH TIME:
8:00

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D3278-1

Accept



Setup Start



Revision ID:

Item Name: Support

Stop



Start Date: 3/30/2011

Start Qty: 40.00



Cust Item ID:

Required Date: 4/4/2011

Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
Description

160

QC3- Inspect Part Finish



QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Packaging

Packaging

Identify as per dwg & Stock Location: GA

0.00

SB 11/04/12

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MF

11-04-12

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, March 30, 2011 10:36:37 AM

Work Order ID: 67772



Parent Item: D3278-1



Parent Item Name: Support

Start Date: 3/30/2011

Required Date: 4/4/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: CA 04.04.19 New issue KJ/JLM

IPP B 07.09.06 rev.c dwg EC verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00 0		Purchased	No			100	f	47.4400	0.2337	9.84			

6061-T6 Bar 1.00 x 2.00



Location	Loc Qty	Loc Code
MAT004	47.44	
112567	22.6	
114415	4.58	
115045	5.6	
→ 115952 12	8.33	2.97
→ 116623 28	6.33	6.87

ark/taylor

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	67772
Description: Support	Part Number:	D3278-1
Inspection Dwg: D3278 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	0.098	—		Vern Ml-7	
0.359	+/-0.005	-358	—		"	
0.609	+/-0.010	615	—		"	
0.250	+/-0.010	250	—		"	
1.480	+/-0.005	1.480	—		"	
R0.125	+/-0.010	R.125	—		Rad-gage	
0.119	+0.005/-0.004	-121	—		Vern Ml-7	
2.439	+/-0.010	2.441	—		"	
1.980	+/-0.010	1.983	—		"	
R0.13	+/-0.030	R.125	—		Rad-gage	
Ø0.257	+0.005/-0.000	Ø.258	—		Vern Ml-7	
R0.375	+/-0.010	R.375	—		Rad-gage	
0.875	+/-0.010	.875	—		Vern Ml-7	
0.500	+/-0.010	.500	—		"	
R0.400	+/-0.010	R.400	—		Rad-gage	
R1.00	+/-0.030	R1.000	—		"	
1.720	+/-0.010	1.724	—		Vern Ml-7	
R0.125	+/-0.010	R.125	—		Rad-gage	
0.125	+/-0.010	.125	—		Vern Ml-7	

Measured by:	<i>GML</i>	Audited by:	<i>B.A.</i>	Prototype Approval:	N/A
Date:	11/04/06	Date:	11/04/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC <i>[initials]</i>	<i>EZ</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

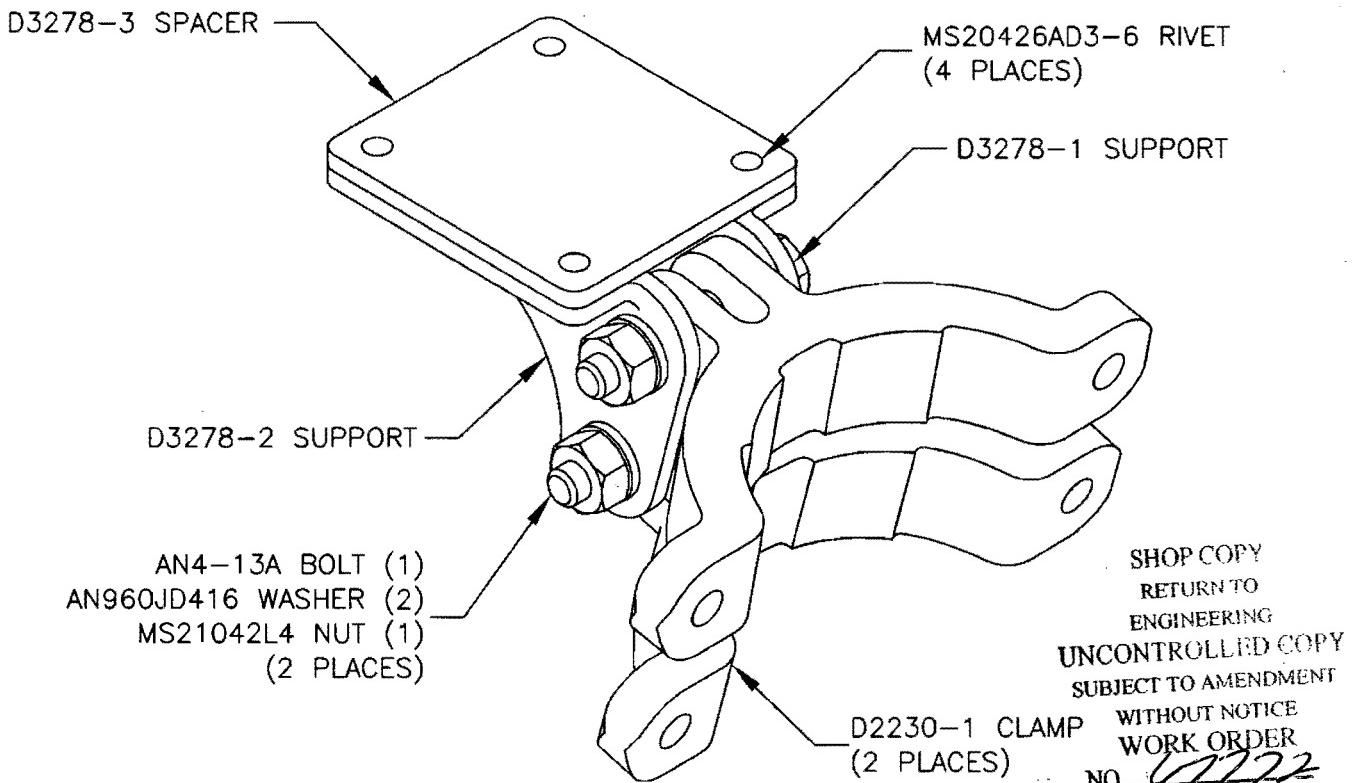
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>9P</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>44</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
*07.08.06*D3278-041 SUPPORT ASSEMBLY

Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

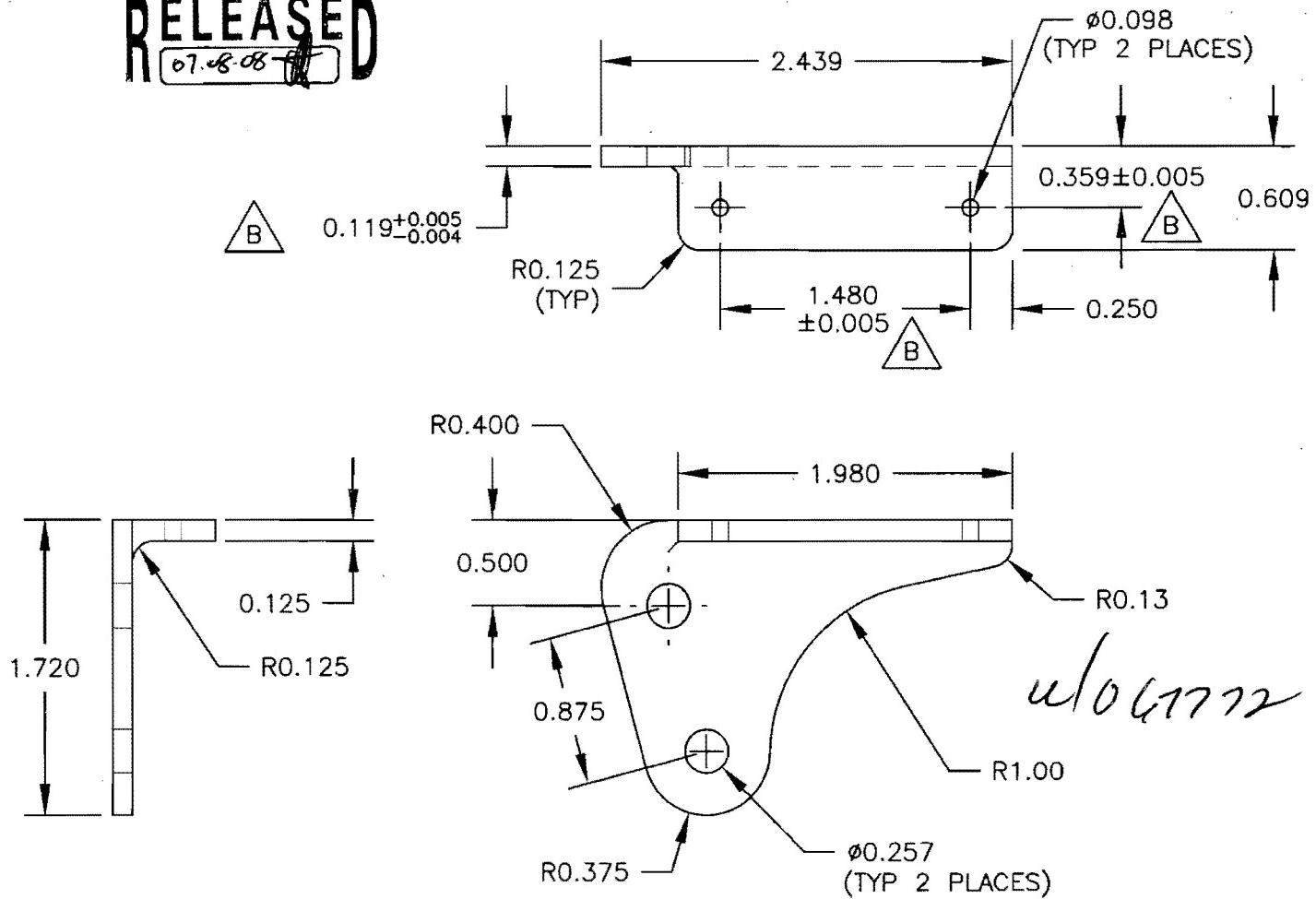
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN <i>9P</i>	DRAWN BY <i>Jc</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JS</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
67-08-08-~~08~~**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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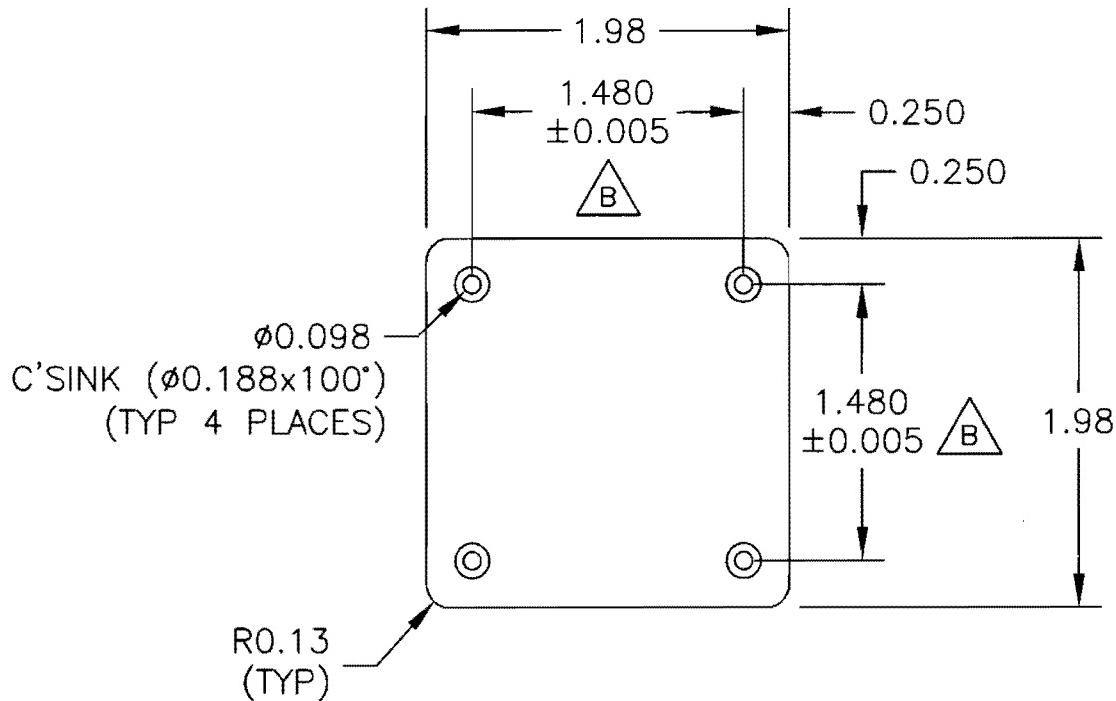
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DART

DESIGN <i>GP</i>	DRAWN BY <i>JL</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>BS</i>	APPROVED <i>LL</i>	DRAWING NO. D3278	REV. C	SHEET 3 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY	SCALE 1:1		

RELEASED
07.08.08*wba7772***D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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